

The Examiner has rejected claim 6 as being indefinite. The term "enhanced smoothness" is a relative term and it is unclear with respect to what the smoothness is "enhanced". The original disclosure provides no guidance on how the term should be interpreted.

Applicant has canceled claim 6.

The Examiner has rejected claim 8 as being indefinite. The term "publication grade paper" is indefinite. The term is not defined in the specification, nor does the term have an art accepted meaning. Applicant must amend the claim, show where the term is defined in the original disclosure, or provide the Office with a reference that defines the term and predates the prior date of the current application.

Publication grade paper is defined on page five of the specification as label paper or other printing and writing grades of paper. Page 11 further defines publication grade paper as MG or MF or other printing, writing or label grades, or may have printed graphics. Further, Applicant has enclosed references that define the term and predate the prior date of the application.

The Examiner has rejected claim 9 as being indefinite. The term "label stock grade" is indefinite. The term is not defined in the specification, nor does the term have an art accepted meaning. Applicant must amend the claim, show where the term is defined in the original disclosure, or provide the Office with a reference that defines the term and predates the prior date of the current application.

Label stock grade is a term of art with an accepted meaning. Applicant has enclosed references that define the term and predate the prior date of the application.

The Examiner has rejected claim 1-4 and 6-13 as being obvious over Cavagna, 4,898,752, in view of Peer, 4,254,173. The Examiner states that Cavagna teaches outer packaging materials are made of paperboard comprising unbleached kraft paperboard that has been surface treated on at least one side with a white coating or the like. The white coating may be applied as a thin layer of high quality label paper. The white surface may further have a clay coating applied thereto.

Cavagna does not teach that the paperboard should further comprise a top ply overlaying said white layer. However, Peer teaches a plastic film that can be applied over outer packaging paper materials. The plastic film provides tear resistance to the composite and may be reverse printed on their inner surface. The plastic film is selected from the group consisting of polyethylene, polypropylene, and PET. Therefore, the Examiner takes the position that it would have been obvious to apply the adhesive/plastic layer taught in Peer to the outer packaging taught in Cavagna in order to improve the tear resistance of the packaging.

Cavagna relates to a method for making coated and printed packaging material on a printing press. Unbleached paper and paperboard for use as outer packaging material is coated and printed on a printing press. It is custom in the industry to finish at least one surface with a white coating, to permit printing of the naturally brown, rough surface of the unbleached board. One method has been to coat one surface of the board with a coating composition comprising latex, clay and titanium dioxide. In other cases, an outer thin layer of high-quality label paper or a plastic film have been laminated to one surface of the unbleached paper-board to provide a printable surface. Containers of corrugated

packages and single ply folding cartons employ white surfaced (clay coated) unbleached kraft board.

Peer relates to a composite material for secondary container packaging material for use in six pack can wraps, six pack bottle carriers, twelve pack carriers, comprising a composite of a paper material laminated to a plastic film. The plastic film provides tear resistance to the composite. Natural kraft paper and recycled paper are preferred. Preferred films permit reverse printing on their inner surface. Adhesives bond film to the paper. Film may be metallized to produce a foil effect.

Peer relates to an inner paper, outer decorative plastic film and adhesive layer between. Most secondary container packaging is made of paper or paperboard. The board is usually made from virgin, strong fiber. A smooth white surface is coated to the carrier board with a white clay titanium dioxide-layer mixture. The white surface is added to permit decoration of the naturally brown, rough surface of the carrier board. In some cases, a white outer surface is provided through the lamination of an outer thin layer of high quality label paper to a thicker backing material. Peer teaches laminating a paper material, such as kraft paper or recycled board to a transparent film.

Claim 1 requires a two-ply base label comprised of a bottom ply and a top ply. The bottom ply is comprised of unbleached cellulosic fibers and the top ply is comprised of bleached or brightened cellulosic fibers. A layer of paper or film is attached to the top ply with a layer of adhesive. The adhesive contains no pigment and the top surface of the further layer has no coating.

Cavagna teaches an unbleached paper having a white paper or plastic attached to it. Peer teaches an unbleached paper having a film attached by an adhesive. Claim 1

requires a layer of paper or film attached to the top ply or bleached paper with a layer of adhesive. Therefore, the combination of Peer and Cavagna does not teach a two ply base layer having the layer of paper or film attached to the top ply. Further, there is nothing taught in Cavagna which would suggest the need for a further layer to help with tear resistance. Therefore Claim 1 is not obvious over Cavagna in view of Peer.

The Examiner takes the position that any adhesion would meet the "barrier for moisture, oil and odor" limitation of claim 7 because any substance will restrict moisture, oil and odor transmission to some extent.

Claim 7 requires that the adhesive is a barrier for moisture, oil and odor. Claim 7 is not obvious over Cavagna in view of Peer because they do not disclose a two-ply base, the bottom ply comprising unbleached cellulosic fibers and the top ply comprising bleached or brightened cellulosic fibers; a layer of paper or film attached to the top ply with a layer of adhesive.

With respect to claim 8, the Examiner takes the position that the label grade paper taught in Cavagna is a publication grade paper. The Examiner relies upon Applicant's disclosure on page 11 of the specification (last paragraph) where label grades are listed as a type of publication grade paper.

Claim 8 requires that the paper sheet is a publication grade. Claim 8 is not obvious over Cavagna in view of Peer because they do not disclose a two-ply base, the bottom ply comprising unbleached cellulosic fibers and the top ply comprising bleached or brightened cellulosic fibers; a layer of paper or film attached to the top ply with a layer of adhesive.

Claim 9 requires that the paper sheet is a label stock grade. Claim 9 is not obvious over Cavagna in view of Peer because they do not disclose a two-ply base, the bottom ply comprising unbleached cellulosic fibers and the top ply comprising bleached or brightened cellulosic fibers; a layer of paper or film attached to the top ply with a layer of adhesive.

Claim 10 requires that the paper sheet has a coating. Claim 10 is not obvious over Cavagna in view of Peer because they do not disclose a two-ply base, the bottom ply comprising unbleached cellulosic fibers and the top ply comprising bleached or brightened cellulosic fibers; a layer of paper or film attached to the top ply with a layer of adhesive. Further Cavagna in view of Peer does not teach that the paper sheet has a coating.

Claim 11 requires that the coating is selected from clay and protein and/or starch or titanium dioxide. Claim 11 is not obvious over Cavagna in view of Peer because they do not disclose a two-ply base, the bottom ply comprising unbleached cellulosic fibers and the top ply comprising bleached or brightened cellulosic fibers; a layer of paper or film attached to the top ply with a layer of adhesive. Further Cavagna in view of Peer does not teach that the paper sheet has a coating.

Claim 12 requires that the film is a tear resistant film. Claim 12 is not obvious over Cavagna in view of Peer because they do not disclose a two-ply base, the bottom ply comprising unbleached cellulosic fibers and the top ply comprising bleached or brightened cellulosic fibers; a layer of paper or film attached to the top ply with a layer of adhesive.

Claim 13 requires that the film is reverse printed. Claim 13 is not obvious over Cavagna in view of Peer because they do not disclose a two-ply base, the bottom ply comprising unbleached cellulosic fibers and the top ply comprising bleached or brightened cellulosic fibers; a layer of paper or film attached to the top ply with a layer of adhesive.

The Examiner states that with regard to claim 3, Cavagna does not explicitly teach what materials may be utilized in the production of the paperboard layer. However, Peer teaches that outer packaging is usually made from kraft pulp or recycled paper pulp. Thus, it would have been obvious to make the paperboard taught in Cavagna from either virgin kraft pulp or recycled pulp because Peer teaches said materials are traditionally used in the production of outer packaging.

Claim 3 requires that the unbleached cellulosic fibers are selected from unbleached virgin Kraft pulp and unbleached recycled pulp. Claim 3 is not obvious over Cavagna in view of Peer because they do not disclose a two-ply base, the bottom ply comprising unbleached cellulosic fibers and the top ply comprising bleached or brightened cellulosic fibers; a layer of paper or film attached to the top ply with a layer of adhesive.

With respect to claim 2, the Examiner takes the position that the graphics produced using the adhesive/polymer overlay taught in Peer are "high quality" since they are sufficient for consumer appeal.

Claim 2 requires that the sheet is capable of making products having high quality graphics. Claim 2 is not obvious over Cavagna in view of Peer because they do not disclose a two-ply base, the bottom ply comprising unbleached cellulosic fibers and the

top ply comprising bleached or brightened cellulosic fibers; a layer of paper or film attached to the top ply with a layer of adhesive.

The Examiner takes the position that the laminate taught in Cavagna meets the limitations of claim 4. Specifically, Cavagna teaches a paperboard coated with a "thin" paper layer. Paperboard is generally understood to refer to cellulose fiber materials that are thicker than paper. Amended claim 4 requires that the bottom ply is thicker than the top ply.

Claim 4 is not obvious over Cavagna in view of Peer because they do not disclose a two-ply base, the bottom ply comprising unbleached cellulosic fibers and the top ply comprising bleached or brightened cellulosic fibers; a layer of paper or film attached to the top ply with a layer of adhesive.

The Examiner has rejected claim 5 as being obvious over Cavagna, in view of Peer, as applied to claims 1-4 and 6-13. Cavagna in view of Peer is relied upon as above, but neither reference teaches that the label paper should have a brightness of above 60ISO. However, it is known in the art to increase the brightness of a printing/imaging paper in order to enhance the image clarity. Thus, it would have been obvious to increase the brightness of the label paper taught in Cavagna in order to enhance the image clarity of the resulting secondary package material.

Claim 5 requires that the top ply have a brightness of above 60ISO.

Claim 5 is not obvious over Cavagna in view of Peer because they do not disclose a two-ply base, the bottom ply comprising unbleached cellulosic fibers and the top ply comprising bleached or brightened cellulosic fibers and a layer of paper or film attached to the top ply with a layer of adhesive.

The Examiner has rejected claim 14 as being obvious over Cavagna in view of Peer, as applied to claims 1-4 and 6-13. Cavagna in view of Peer is relied upon as above, but neither reference teaches that the tear resistant film taught in Peer may be pigmented. However, matters relating to ornamentation only which have no mechanical function cannot be relied upon to patentably distinguish the claimed invention from the prior art. Thus, the Examiner takes the position that it would have been obvious to apply pigment to the tear resistant film taught in Peer in order to obtain the desired aesthetic effect.

Claim 14 requires that the film contains a pigment. Claim 14 is not obvious over Cavagna in view of Peer because they do not disclose a two-ply base, the bottom ply comprising unbleached cellulosic fibers and the top ply comprising bleached or brightened cellulosic fibers, a layer of paper or film attached to the top ply with a layer of adhesive.

The Examiner has rejected claims 15-19 as being obvious over Cavagna in view of Peer as applied to claims 1-4 and 6-13 and further in view of Confer, 3,603,501. Cavagna in view of Peer is relied upon as above. Cavagna teaches that the paperboard core may be finished on both surfaces with a label paper. The examiner takes the position that an inner label paper would read on the claimed moisture absorbent layer. Cavagna does not teach that such label papers are adhered to the paperboard core. However, Confer teaches that secondary packaging materials are generally made by adhering the label paper to the paperboard core. Thus, it would have been obvious to apply adhesive between the label paper and the paperboard core taught in Cavagna because Confer teaches that such a laminating technique is the traditional method by

which secondary packaging is processed. The Examiner takes the position that any adhesive is a barrier to moisture to some extent.

Confer relates to a carton having tear strips for cans. The invention relates to an open end carton of six pack type having longitudinal slits on corner edges, one for each can. Carton blanks are made by laminating continuous label web and backing web wide enough for several blanks with longitudinal reinforcing strands between webs, and spaced laterally at margins and lines of division of master strip.

The carton is made from paperboard folded along appropriate lateral lines. The blank is a lamination of an outer thin layer of high quality label paper to receive desired printed matter and an inner considerably thicker layer of backing paper to provide strength and reasonable rigidity.

Claim 15 requires an additional layer of paper or board attached to the bottom ply with a second adhesive layer. Claim 15 is not obvious over Cavagna in view of Peer and further in view of Confer. None of these patents alone or in combination discloses a two ply base, the bottom ply comprising unbleached cellulosic fibers and the top ply comprising bleached or brightened cellulosic fibers; a layer of paper or film attached to the top ply with a layer of adhesive and an additional layer of paper or board attached to the bottom ply with a second adhesive. Further, there is nothing taught in Cavagna to add two additional layers. Therefore, claim 15 is not obvious over the prior art references.

Claim 16 requires that the additional layer is comprised of unbleached cellulosic fibers selected from unbleached virgin Kraft pulp and unbleached recycled pulp. Claim 16 is not obvious over Cavagna in view of Peer and further in view of Confer. None of these patents alone or in combination discloses a two ply base, the bottom ply comprising

unbleached cellulosic fibers and the top ply comprising bleached or brightened cellulosic fibers; a layer of paper or film attached to the top ply with a layer of adhesive and an additional layer of paper or board attached to the bottom ply with a second adhesive. Therefore, claim 16 is not obvious over the prior art references.

Claim 17 requires that the additional layer of claim 15 is a moisture absorbent layer. Claim 17 is not obvious over Cavagna in view of Peer and further in view of Confer. None of these patents alone or in combination discloses a two ply base, the bottom ply comprising unbleached cellulosic fibers and the top ply comprising bleached or brightened cellulosic fibers; a layer of paper or film attached to the top ply with a layer of adhesive and an additional layer of paper or board attached to the bottom ply with a second adhesive. Therefore, claim 17 is not obvious over the prior art references.

Claim 18 requires that the second adhesive layer is not significantly absorbed by the moisture absorbent layer and acts as a moisture barrier. Claim 18 is not obvious over Cavagna in view of Peer and further in view of Confer. None of these patents alone or in combination discloses a two ply base, the bottom ply comprising unbleached cellulosic fibers and the top ply comprising bleached or brightened cellulosic fibers; a layer of paper or film attached to the top ply with a layer of adhesive and an additional layer of paper or board attached to the bottom ply with a second adhesive. Therefore, claim 18 is not obvious over the prior art references.

Claim 19 requires that the second adhesive layer is selected from hot melt glues or glues that are moisture and/or oil resistant. Claim 19 is not obvious over Cavagna in view of Peer and further in view of Confer. None of these patents alone or in combination discloses a two ply base, the bottom ply comprising unbleached cellulosic

fibers and the top ply comprising bleached or brightened cellulosic fibers; a layer of paper or film attached to the top ply with a layer of adhesive and an additional layer of paper or board attached to the bottom ply with a second adhesive. Cavagna teaches a paperboard coated with a thin paper layer. Therefore claim 19, is not obvious over the prior art references.

The Examiner has rejected claims 15-19 as being obvious over Cavagna in view of Peer, as applied to claims 1-4 and 6-13, and further in view of Hall, 4,441,626. Cavagna in view of Peer is relied upon as above, but neither reference teaches that a wicking material may be attached to the interior of packaging material. However, Hall teaches that a single sided corrugated cardboard medium may be glued to the interior of a package in order to absorb liquids from the packaged material. The wicking cardboard is attached to the package with a moisture resistant adhesive. Thus, it would have been obvious to adhere a single sided corrugated cardboard to the interior of the secondary packaging material taught in Cavagna in order to absorb undesirable liquids around the packaged material.

Hall relates to a pizza box. A box is formed from a unitary, double-sided corrugated cardboard blank having a plurality of scored lines. A bottom panel of the box has cemented thereto a single-sided, fluted corrugated cardboard medium with the fluted side facing upwardly. A moisture resistant glue is used between the smooth faces of the fluted corrugated medium and the confronting liner of the blank to provide an impenetrable barrier which prevents grease from penetrating through the box.

A bleached white medium is corrugated into upper flute. The bleached medium, which comes into direct contact with the pizza is sanitary, and has a clean fresh look (as

computed to conventional brown Kraft paper). The medium is glued to a liner pulled from a roll of heavy Kraft paper. The bleached white flutes are preferably adhered to liner by a regular water resistant starch adhesive. An unbleached Kraft paper medium is corrugated to form lower flutes. The E-fluted medium is then glued to a heavy Kraft paper liner.

The two, single-faced corrugated cardboards, formed are transported to another work station where the smooth faces of the liner are laminated together, with a moisture-resistant glue which forms the moisture barrier.

Claim 15 and the claims which depend on it, claims 16-19 are not obvious over Cavagna in view of Peer and further in view of Hall. None of these references alone or in combination discloses a two ply base, the bottom ply comprising unbleached cellulosic fibers and the top ply comprising bleached or brightened cellulosic fibers, a layer of paper or film attached to the top ply with a layer of adhesive and an additional layer of paper or board attached to the bottom ply with a second adhesive. Therefore, claims 15-19 are not obvious over the prior art references.

Hall relates to a pizza box and does not teach the two-ply base layer having an additional layer of paperboard attached with adhesives to both the top ply and the bottom ply.

The Examiner has rejected claims 20-23 as being obvious over Cavagna in view of Peer, as applied to claims 1-4 and 6-13 above, and further in view of Knudson, 4,913,773. Cavagna in view of Peer is relied upon as above, but neither reference teaches that the paperboard core may comprise more than one layer of paperboard. However, Knudson teaches a multi-ply paperboard comprising one ply of high bulk fibers

sandwiched between at least two plies of conventional papermaking fibers. A bonding agent may be utilized between the layers. Said paperboard has superior stiffness in comparison to traditional paperboard. Stiffness is important in folding carton applications. Thus it would have been obvious to utilize the multi-ply paperboard taught in Knudson in the laminate taught in Cavagna to increase the stiffness of the laminate.

Knudson relates to a method of producing a multi-ply paperboard comprising at least one ply high bulk fibers sandwiched between at least two plies of conventional papermaking fibers. High bulk fibers characterized by twists, kinks, and curls are produced by mechanical deformation without substantial fibrillation or breakage of the fibers.

The invention relates to a method for the manufacture of a multi-ply paperboard mat, and to a multi-ply paperboard not having premium fiber outer plies and an interior ply of high bulk fibers.

Claim 20 relates to a laminated sheet comprising a pair of two ply base layers each comprised of a bottom ply and a top ply. The bottom ply is comprised of unbleached cellulosic fibers and the top ply is comprised of bleached or brightened cellulosic fibers. The adhesive layer is disposed between the base layers, adhering the bottom plies of each base layer together so that the top plies remain visible.

Claim 20 is not obvious over Cavagna in view of Peer and further in view of Knudson. None of the prior art references alone or in combination disclose a pair of two-ply base layers each comprised of a bottom ply and a top ply wherein the bottom ply is comprised of unbleached cellulosic fibers and the top ply is comprised of bleached or brightened cellulosic fibers. The adhesive layer is disposed between the base layers

adhering the bottom plies in each base layer together. Knudson relates to a method of producing multiply paperboard wherein at least one ply of high bulk fibers is sandwiched between at least two plies of conventional papermaking fibers. The combination Cavagna, Peer and Knudson does not make claim 20 obvious.

Claim 21 requires that the sheet is used to make products having high quality graphics. For the reasons stated above for claim 20, claim 21 is not obvious over Cavagna in view of Peer and Knudson.

Claim 22 relates to the composite sheets of claim 1 further comprising a second two-ply base layer having a bottom ply and a top ply. The bottom ply is comprised of unbleached cellulosic fibers and the top ply is comprised of bleached or brightened cellulosic fibers. The bottom ply of the second two-ply base layer is attached to the bottom ply of the first two-ply base layer with a second layer of adhesive. For the reasons stated above for claim 20, claim 22 is not obvious over Cavagna in view of Peer and Knudson.

Claim 23 relates to the composite sheet of claim 22 and further comprises a layer attached to the top ply of the second two-ply base layer with a layer of adhesive. The layer has a top and bottom surface. The layer consists of paper or film. The layer of

adhesive contains no pigment and the top surface of the layer has no coating. For the reasons stated above for claim 20, claim 23 is not obvious over Cavagna in view of Peer and Knudson.

Applicant believes that the application is now in condition for allowance.

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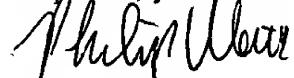
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Signature: Debbie Brodwick

Name: Debbie Brodwick

Respectfully submitted,



Philip M. Weiss

Reg. No. 34,751

Attorney for Applicant

Weiss & Weiss

310 Old Country Rd., Ste. 201

Garden City, NY 11530

(516) 739-1500

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Tape	Material	UL Recognized	Elongation (Percent)	Dielectric Strength (Volts)	Insulation Class ° C.	Adhesive System	Color	Adhesion** (oz/in.)
#4001	POLYESTER	YES	100	5000	130	ACRYLIC	YELLOW	30
#4002	POLYESTER	YES	100	5000	130	ACRYLIC	CLEAR	30
#4004	POLYESTER	YES	100	5000	130	ACRYLIC	BLACK	30
#4010	POLYESTER	YES*	100	5100	130	SILICONE	CLEAR	30
#4011	POLYIMIDE	YES	50	6800	180	SILICONE	AMBER	20
#4013 ***	POLYESTER	YES*	100	5400	130	ACRYLIC	WHITE	30
#7001	POLYESTER	YES*	100	5000>	130	SILICONE	WHITE	30
#7015	POLYESTER	YES*	100	5100	130	SILICONE	BLACK	25

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#7011 ***	PAPER	3.5	30	RUBBER	WHITE	42

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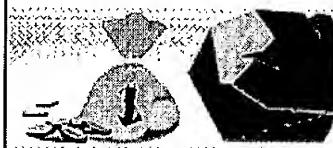
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SBS - Solid Bleached Sulfate Paperboard

Refers to the type of white paperboard typically used to produce paper plates, press formed trays, folding cartons, and milk cartons.

Scoring

The process of pressing dull steel rule blades into the paperboard under pressure in order to control the folding of the paperboard during forming or folding.

Sheet Fed

Any process where the paperboard is fed in sheets into the press.

Spring Back

The amount that the sidewall of a plate or tray relaxes after the plate or tray is removed from the forming die.

Stacker

The apparatus at the end of a delivery table used to stack plates or trays for packing

Steel Rule Die Cutting

Traditional sharpened steel rule bent to the shape of the desired blank and mounted in plywood. Typically used for producing samples and developing a blank. Also used in high production steel rule die cutters for cartons and corrugated.

Top In

Length and width of a container measured at the top of the sidewall of the container.

Top Out

Length and width of a container measured at the outside edges at the top of the container.

Tray in a Carton

A traditional packaging concept with a film sealed tray in a folded carton. The tray could be foil, pressformed paper, molded pulp, CPET, etc.

Twist

Created by incorrect die alignment. As trays are stacked, the stack starts to twist as it is increased in height.

Web Offset Printing

The process typically used to print high quality graphics on folded cartons. Use etched metal plate to transfer the image.

Web Fed

Any process where the paperboard is fed from a roll into the machine. Wrinkles (uncontrolled) - Uncontrolled gathering or folding of paperboard during the feeding process -- typically caused by incorrect scoring, low moisture, loose die clearance, or incorrect paper tension.

or low draw ring pressure.

A-B **C** **D** **E-F** **G-M** **O-P** **S-W**

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Focus on Paper and Paperboard

Converting Magazine, May 2000 v18 i5 52(2)

Author

Ducey, Michael J.

Full Text

Q: What are the trends in specialty corrugated containers?

A: Big flutes get bigger, and small flutes get smaller.. Having unlocked the performance price mechanism with their material suppliers, structural engineers and packaging designers are accelerating product releases to further diversify corrugated box making.

New corrugated designs are carving out small but important slices of packaging markets where optics and dimensional stability fetch a premium. Barriers to entry are only limited to the imagination, as most material costs are rising and are likely to inflate all year. Meanwhile, suppliers with smaller board machines are looking for new opportunities--short runs with high quality, graphics and unique strength.



Higher graphics quality is no mystery. The self-serve retail phenomena continues unabated. Point-of-purchase displays using small triple-wall kiosks holding small-flute boxes of ready-to-eat foods are a common sight in convenience stores. The small boxes alone are now appearing on the supermarket shelves as lunch-box items, following the trend in aseptic juice boxes. Consumer brand companies are supplying storage for the home lunch maker with small flute boxes featuring full-coverage printing in deep colors.

Smaller flute snags markets

The small flute, known commercially as N-flute, is not a new concept. MicroFlute by Cecor (owned by Georgia-Pacific) is a well-established brand in the corrugated box industry, and has been joined by other big names. However, new entrants are marching into the market with even smaller flutes-with equal strength and the capacity for high-quality graphics.

Popular white-board brands include Westvaco, St. Laurent, International Paper and, among imports, KemiArt from Metsa (Finland). Hot applications include specialty foods (like wine), snack foods, impulse items and toys.

Small flute still only occupies a tiny fraction (perhaps 5%), of the 370 billion sq.ft. of corrugated boxes shipped in 1999, but it is growing 10 times as fast as the 2% growth rate of the corrugated-container industry as a whole.

Some reports will claim that N-flute appeared first in Europe. Retail consumer products companies achieved the limit on quality with folding carton stock from recycled coated paperboards, and were looking for higher-quality graphics and high strength in small quantities. Folding carton stock and brown liners had printing and converting limitations.

Coated boards were most economically purchased in big quantities, making it tough for small converters who frequently changed grade runs. The coating itself had occasional problems: delamination, cracks at the fold, and whiteness. Brown paper had obvious graphic limitation: especially when using the dark shades favored by boutique consumer packaging designers.

During the poor economic conditions of the paper industry, prices between white and brown liners narrowed, and product design of N-flute blossomed. Today, most luxury items (food and non-food) are divided along price points, in part between folding cartons and N-flute.

Retailers also save with small flute packaging. By receiving and stocking products that do not require a master carton and which stack evenly right out of the wrapper (shrink or stretch wrap film), waste and handling are reduced. Most of all from a marketing standpoint, the bright packages grab shoppers' attention.

Triple wall faces challenges

At the other end of the corrugating spectrum is the triple-wall box. This mammoth packaging material is sensitive in all converting operations because of the potential for costly waste. In producing triple wall sheets, bonding, cutting and stacking are critical due to the tremendous amount of fiber at stake. Hot plates must keep the heat gradient up through the web in order to evenly cure the starch adhesive bond. Cutting equipment must be kept extra clean (no paper dust or shavings) and sharp to avoid jams and uneven edges. Material itself must have absolutely uniform moisture throughout each ply in order to promote lay-flat and even stacking.

Strength properties are emphasized in most applications. In non-food markets like automotive, the heavy pieces of equipment need supreme dimensional stability to avoid in-transit damage. In food, moisture barrier and form are needed for items like watermelons and cantaloupe. Food items sometimes require graphics because they are on display in the carton—a major focus of product expansion in self-serve retail.

High quality graphics is currently a big area of development. The big guys have all acquired more production capacity including IP (Union Camp), Georgia-Pacific (Connelly), Weyerhaeuser (Tri-Wall) and others. All have great resources to develop triple wall products with high quality graphics using white boards, lighter browns and new surface qualities—quite different from the small flute development world, which often originates in a pre-fab building in an out-of-town industrial park. Look for more triple wall applications as master cartons for loose food and non-food items to solve stacking and shelving problems.

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JCP Paper Codes

Code	Description
A10	Newsprint, Basis Size 24 X 36"
A100	Antique Book, Basis Size 25 X 38"
A110	50 Pct Antique Book, Basis Size 25 X 38"
A120	50 Pct Laid-Antique Book, Basis Size 25 X 38"
A150	Uncoated Vegetable-Fiber Book, Basis Size 25 X 38"
A165	Heat-Set Web Offset Coated Book, Basis Size 25 X 38"
A170	Litho (Gloss) Coated Book, Basis Size 25 X 38"
A175	(Publication Grade) Gloss Coated Book, Basis Size 25 X 38"
A180	(Gloss) Coated Book, Basis Size 25 X 38"
A181	No. 1 Coated Text, Gloss-Finish, Basis Size 25 X 38"
A182	No. 2 Coated Text, Gloss-Finish, Basis Size 25 X 38"
A20	Machine-Finish Book, Basis Size 25 X 38"
A205	Litho Coated Book, Basis Size 25 X 38"
A220	Water-Resistant (Text) Book, Basis Size 25 X 38"
A235	(Publication Grade) Matte Coated Book, Basis Size 25 X 38"
A240	Matte Coated Offset Book, Basis Size 25 X 38"
A25	Heat-Set Web Offset Machine-Finish Book, Basis Size 25 X 38"
A250	Laid-Finish Book, White and Colored, Basis Size 25 X 38"
A260	Dull Coated Offset Book, Basis Size 25 X 38"
A261	No. 1 Coated Text, Dull-Finish, Basis Size 25 X 38"
A262	No. 2 Coated Text, Dull-Finish, Basis Size 17 X 22"
A270	Uncoated Permanent Book, White and Cream-White, Basis Size 17 X 22"
A50	Machine-Finish Book End, Basis Size 25 X 38"
A55	Heat-Set Web Offset Book, Basis Size 25 X 38"
A60	Offset Book, Basis Size 25 X 38"
A61	No. 1 Offset Book Smooth-Finish, Basis Size 25 X 38"
A63	Offset Book, Colored, Basis Size 25 X 38"
A65	Light Weight Heat-Set Web Offset Book (Bible Paper), Basis Size 25 X 38"
A70	100 Pct Recycled Offset Book, Basis Size 25 X 38"
A72	Flexural Offset Book, Basis Size 25 X 38"
A75	Light Weight Offset Book (Bible Paper), Basis Size 25 X 38"
A80	Opacified Offset Book, Basis Size 25 X 38"
A90	Vellum-Finish Book, White and Colored, Basis Size 25 X 38"
A95	Hi-Bulk Offset (Return Mailer), Basis Size 25 X 38"
B10	Mimeograph, White and Colored, Basis Size 17 X 22"
D10	Writing, White and Colored, Basis Size 17 X 22"
D15	Writing (Tablet Grade), Basis Size 17 X 22"
D50	100 Pct Fine Writing, Basis Size 17 X 22"
E10	50 Pct Map, Lithographic-Finish, Basis Size 17 X 22"
E20	High Wet Strength Map, Lithographic-Finish, Basis Size 17 X 22"
E30	Offset Map, Lithographic-Finish, Basis Size 25 X 38"
E40	Chemical Wood Map, Lithographic-Finish, Basis Size 17 X 22"
E50	50 Pct Chart, Lithographic-Finish, Basis Size 17 X 22"

F10	Manifold, White and Colored, Basis Size 17 X 22"
G05	Forms Bond, White and Colored, Basis Size 17 X 22"
G10	Bond, Basis Size 17 X 22"
G15	Recycled Groundwood Forms Bond, Natural and Colored, Basis Size 17 X 22"
G40	25 Pct Bond, Basis Size 17 X 22"
G45	Recycled 25 Pct Bond, White and Colored, Basis Size 17 X 22"
G50	25 Pct Translucent Bond, Basis Size 17 X 22"
G60	25 Pct Opacified Bond, White and Buff, Basis Size 17 X 22"
G65	Recycled 25 Pct Opacified Bond, Basis Size 17 X 22"
G70	50 Pct Bond, Basis Size 17 X 22"
G80	100 Pct Bond, Basis Size 17 X 22"
H10	100 Pct Parchment Deed, Basis Size 17 X 22"
H20	100 Pct Cream-White Artificial Parchment, Basis Size 20 X 26"
H30	Imitation Parchment, Laser-Finish, White, Natural, and Colored, Basis Size 20 X 26"
H40	100% Diploma Parchment, Natural White, Basis Size 17 X 22"
J10	Ledger, White and Colored, Basis Size 17 X 22"
J20	25 Pct Ledger, Basis Size 17 X 22"
J30	100 Pct Ledger, Basis Size 17 X 22"
K10	Index, White and Colored, Basis Size 25.5 X 30.5"
K20	25 Pct Index, White and Colored, Basis Size 25.5 X 30.5"
K30	100 Pct Cream-White Index, Basis Size 20 X 26"
L10	Litho Coated Cover, White and India Tint, Basis Size 20 X 26"
L11	No. 1 Coated Cover, Gloss-Finish, Basis Size 20 X 26"
L12	No. 2 Coated Cover, Gloss-Finish, Basis Size 20 X 26"
L20	Vellum-Finish Cover, White and Colored, Basis Size 20 X 26"
L23	Offset Cover, Basis Size 20 X 26"
L30	Cloth-Lined Cover, White and Colored, Basis Size 20 X 26"
L40	Laid-Finish Cover, White and Colored, Basis Size 20 X 26"
L50	L50, Matte Coated Cover, Basis Size 20 X 26"
L60	Dull Coated Cover, Basis Size 20 X 26"
L61	No. 1 Coated Cover, Dull-Finish, Basis Size 20 X 26"
L62	No. 2 Coated Cover, Dull-Finish, Basis Size 20 X 26"
L70	Coated One Side (C1S) Cover, Point Size 8 pt., 10 pt., 12 pt., or 24 pt."
N10	No. 2 Kraft, Basis Size 17 X 22"
O10	Gummed, Conventional Adhesive, Basis Size 17 X 22"
O25	Optical Character Recognition (OCR) Bond, Basis Size 25 X 38"
O40	Latex Saturated Surface Coated, Basis Size 25 X 38"
O50	Masking, Photolithographic (Coated), Basis Size 17 X 22"
O60	Plain Copier, Xerographic, White, Natural and Colored, Basis Size 24 X 36"
O61	High Quality Copier, Laser, Xerographic, Basis Size 17 X 22"
O65	Recycled Plain Copier, Xerographic, Basis Size 24 X 36"
O70	100 Pct Recycled Plain Copier, Xerographic, Basis Size 17 X 22"
P10	High-Finish Manila Tag, Basis Size 22.5 X 28.5"
P20	High-Finish Folder Stock, Basis Size 24 X 36"
Q20	Railroad Board, White and Colored, Basis Size 22.5 X 28.5"
Q50	Chemical Wood Board, Colored, Basis Size 22.5 X 35.5"
Q60	United States Postal Card, White and Colored, Basis Size 24 X 36"
Q80	High-Finish Red Wallet Board, Basis Size 26 X 38"
R10	Pressboard, Colored (Type III), Basis Size 25.2 X 30.2"
R11	Pressboard, Colored (Type I), Basis Size 24 X 36"
R20	Newsboard, Basis Size 25 X 38"
R30	Book Cover Board, Basis Size 25 X 38"

Go To Top

Use information: This paragraph is informational only and is not exclusively definitive of the end use.

For face and back offset printing of books, pamphlets, folders, etc. Printed matter may include text, line illustrations, and light halftones up to 150-line screen.

Stock: Not less than 10 pct postconsumer fiber. Any percent over 10 percentage points, is encouraged, provided that the requirements of this Standard are met.

Grammage (g/m ²)	75	90	105
Basis weight: 25 by 38 inches, 500 sheets (pounds)	50	60	70
A tolerance of ± 5 pct shall be allowed.			
Bursting strength: Average, not less than (kPa)	70	100	170
Equivalent (lb/in ²)	11	15	25
Opacity: Average, not less than (percent)	91	92	93
No individual specimen shall average less than (percent)	89	90	91
Thickness: Average (mm)	0.080	0.095	0.110
Equivalent (inch)	0.0031	0.0037	0.0043
A tolerance of ± 0.013 mm (0.0005 inch) shall be allowed. Paper shall be uniform and shall not vary more than 0.011 mm (0.0004 inch) from one edge to the other.			

Gloss (75°): Average, each side (percent) 10 to 25 10 to 25 10 to 25

Smoothness of coating: Average, each side, not to exceed (units) 120 120 120

General appearance: Paper shall conform to the standard sample(s) adopted by the Government.

Color: The paper in the order (or publication) shall be uniform with the brightness not less than 79 pct. The color variation shall not exceed DE(CIELAB)=1.0.

Formation: Shall be uniform. The coating shall be uniformly applied; shall not be gritty, mottled, stippled, or ribbed in appearance; shall not crack or flake off.

Cleanliness: The dirt count for each side of the paper shall not exceed 100 specks per square meter. No sample sheet (600 to 650 cm² in size) shall contain more than one defect with an equivalent area of 0.25 mm² or greater.

Sampling and testing: Shall be conducted in accordance with standards in Part 2, *Government Paper Specification Standards*.

Unless otherwise specified, the following is automatically waived when printing or duplicating is to be accomplished on commercial contract

Tensile strength: For roll stock only, average, not less than—

Machine direction (kN/m)	2.1	2.7	3.0
Cross direction (kN/m)	1.0	1.2	1.4
Equivalent—			

Machine direction (kg/in)	5.4	6.9	7.6
Cross direction (kg/in)	2.6	3.2	3.7

Color: Shall match the Government's standard sample for color. A deviation of DE(CIELAB)=3.0 from the color standard is allowed.

Curl: Paper shall lie flat with either no tendency to curl or with a curl which can be overcome under reasonable working conditions.

Coating and surface: Shall be uniform, free from mottle or any particles which will pick, lift, fluff, or pile on the blanket under normal press conditions.

Size and trim: Sheets: Paper shall be furnished in the size(s) ordered and shall be flat, trimmed square on four sides with clean smooth edges, and evenly jogged. A tolerance of ± 2 mm ($\frac{1}{16}$ inch) shall be allowed except for sheets 216 by 356 mm (8 $\frac{1}{4}$ by 14 inches) or less; then a tolerance of ± 1 mm ($\frac{1}{32}$ inch) shall be allowed. Successive sheets within any package shall not differ from each other by more than 0.5 mm ($\frac{1}{64}$ inch). Paper with the long dimension 813 mm (32 inches) or less shall be considered square if the variation does not exceed 1 mm ($\frac{1}{32}$ inch); over 813 mm (32 inches); 2 mm ($\frac{1}{16}$ inch).

Rolls: Roll width and diameter shall be as ordered. A tolerance of ± 2 mm ($\frac{1}{16}$ inch) shall be allowed for width and ± 26 mm (1 inch) for diameter.

Roll winding: Roll paper shall be tightly wound at even tension and shall not contain more than the specified maximum number of splices per roll. The number of splices permitted per roll is determined by the roll diameter as ordered. On rolls 1,016 mm (40 inches) or less, a maximum of three splices per roll shall be allowed. On rolls over 1,016 mm (40 inches), a maximum of four splices per roll shall be allowed. Splices shall be neatly and securely overlap-pasted and made with a repulpable adhesive which will not permit the splice to separate. The adhesive may be applied from a tape form backing, provided the backing is removed, leaving only the adhesive component on the splice. The adhesive shall not cause the splice to adhere to adjacent laps. The tails of the splices shall be neatly and evenly removed without damage to adjacent laps. Splices shall be flagged at both ends with projecting colored markers, not pasted to the splice, or otherwise clearly marked.

Grain: Direction of the grain on flat paper shall be as ordered.

Pressroom conditions: The bulk of this paper will be used in air-conditioned pressrooms maintained at 24°C ± 2 °C and 45 pct ± 8 pct relative humidity.

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